



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75222

**\*75222\***

Page 2

October-19-11 11:08:39 AM

Item ID: D3393-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Battery Lock Casing  
 Start Date: 19/10/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 07/11/2011 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>mk 12/02/26</i>		<u>8</u>	<u>2</u>		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>A8</u>	<u>12-2-27</u>	<u>8</u>	
150 <b>*150*</b> Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3  Memo START TIME: <u>3-30</u> OVEN TEMPERATURE: FINISH TIME: <u>4-00</u>	0.00  0.00							<i>8x8 m-12/02/28</i>

*m113645*

*3200 F*

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Page 3

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/29  
 (8)

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**NOTE:** Date & initial all entries

# Picklist Print

October-19-11 11:08:43 AM

Page 1  
1

Work Order ID: 75222

\*75222\*

Parent Item: D3393-1

\*D3393-1\*

Parent Item Name: Battery Lock Casing

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.02.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	25.4000	0.2708	2.280421			

\*M6061T6B1.500X01.500\*

\*\*

6061-T6 Bar 1.50 x 1.50

Location

Loc Qty

Loc Code

MAT010

25.4

107432

1.4

118400

12

✓119231

12

2.281 F.K. 01/10/25

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 75222
<b>Description:</b> Battery Lock Casing		<b>Part Number:</b> D3393-1
<b>Inspection Dwg:</b> D3393	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	Ø0.754	✓		Vern	GA-01
0.625	+0.010/-0.000	0.632	✓		"	"
Ø1.250	+/-0.010	Ø1.248	✓		"	"
1.088	+/-0.010	1.086	✓		"	"
Ø0.734	+/-0.010	Ø0.736	✓		"	"
2.658	+/-0.010	2.655	✓		"	"
1.550	+/-0.010	1.550	✓		"	"
0.125 x 45°	+/-0.010 x 0.5°	0.120 x 45°	✓		"	"
1.50	+/-0.030	1.490	✓		"	"
0.750	+/-0.010	0.743	✓		"	"
Ø1.050	+/-0.010	Ø1.052	✓		"	"
Ø1.000	+/-0.010	Ø1.002	✓		"	"
0.338	+/-0.010	0.343	✓		D-6	GA-08
0.563	+/-0.010	0.565	✓		Vern	GA-01
0.100	+0.000/-0.010	0.096	✓		H-6	31006
3.00	+/-0.030	3.001	✓		Vern	GA-01
1.500	+/-0.010	1.500	✓		"	"
0.375	+/-0.010	0.375	✓		D-6	GA-08
1.25	+/-0.030	1.250	✓		Vern	GA-01
0.125	+/-0.010	0.120	✓		"	"
30°	0.5°	30°	✓		Angle meter	CNC-03

<b>Measured by:</b> B.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/02/25	<b>Date:</b> 12/02/26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	
B	08.11.28	Tolerances revised	KJ/EC	[Signature]

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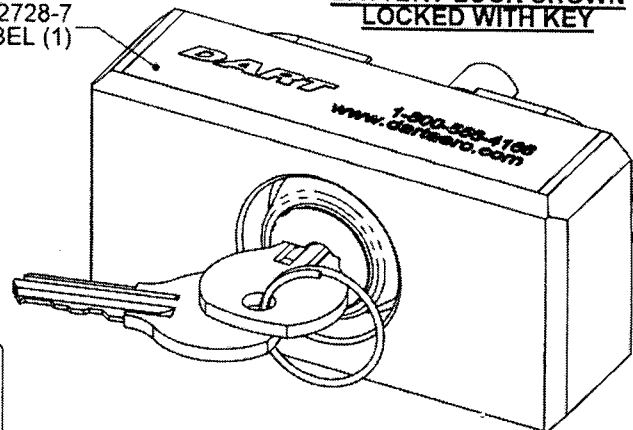
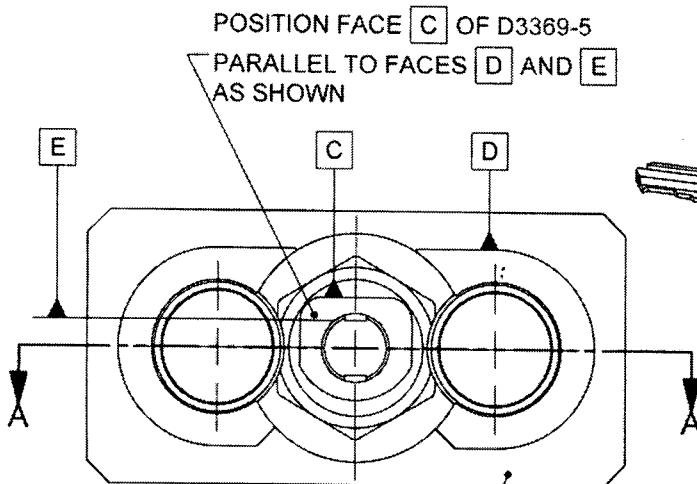


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED 13	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED  
05/03/09

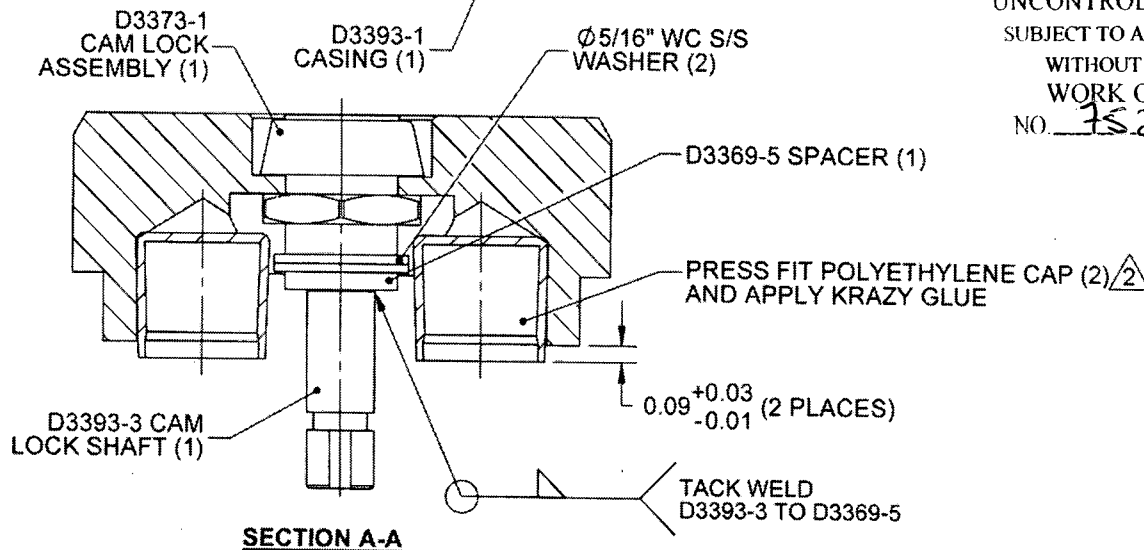
D2728-7  
LABEL (1)

BATTERY LOCK SHOWN  
LOCKED WITH KEY



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 75222

M.L. 5  
11/10/19



### D3393-041 BATTERY LOCK ASSEMBLY

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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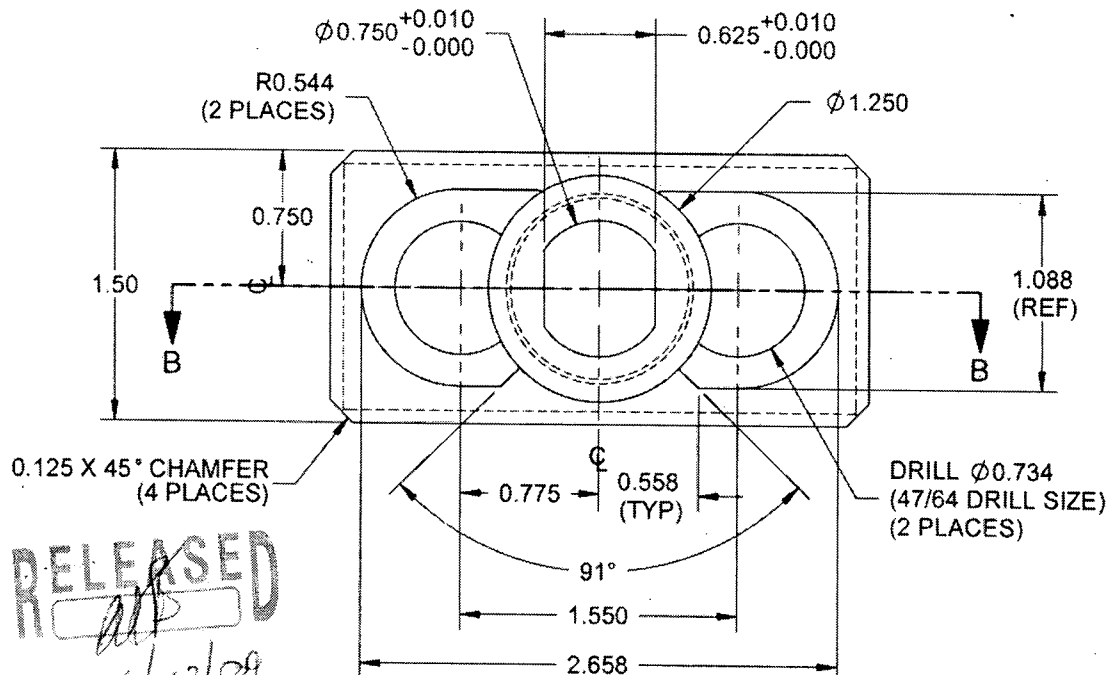
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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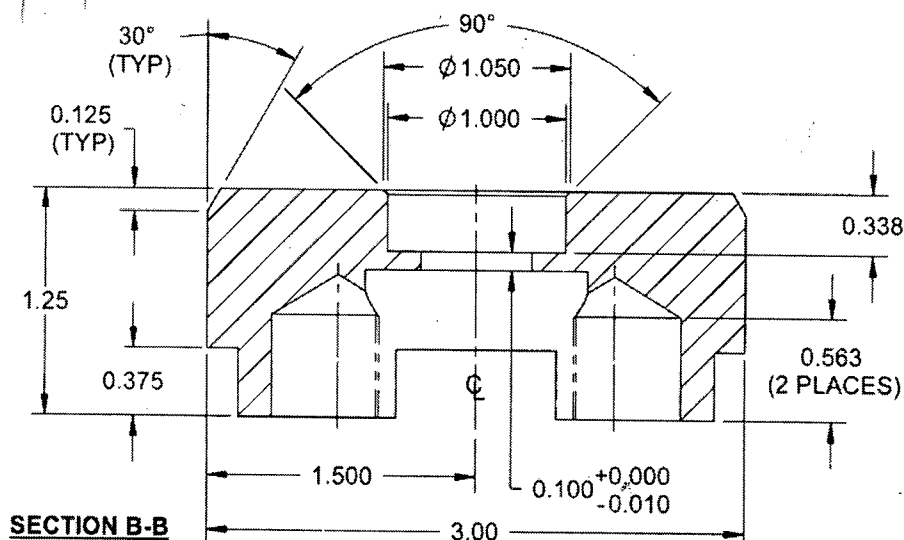
**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A
DATE <b>05.02.09</b>	TITLE <b>BATTERY LOCK</b>	SHEET 2 OF 3	
		SCALE <b>1:1</b>	



RELEASED  
*[Signature]*  
05/03/09



### D3393-1 CASING

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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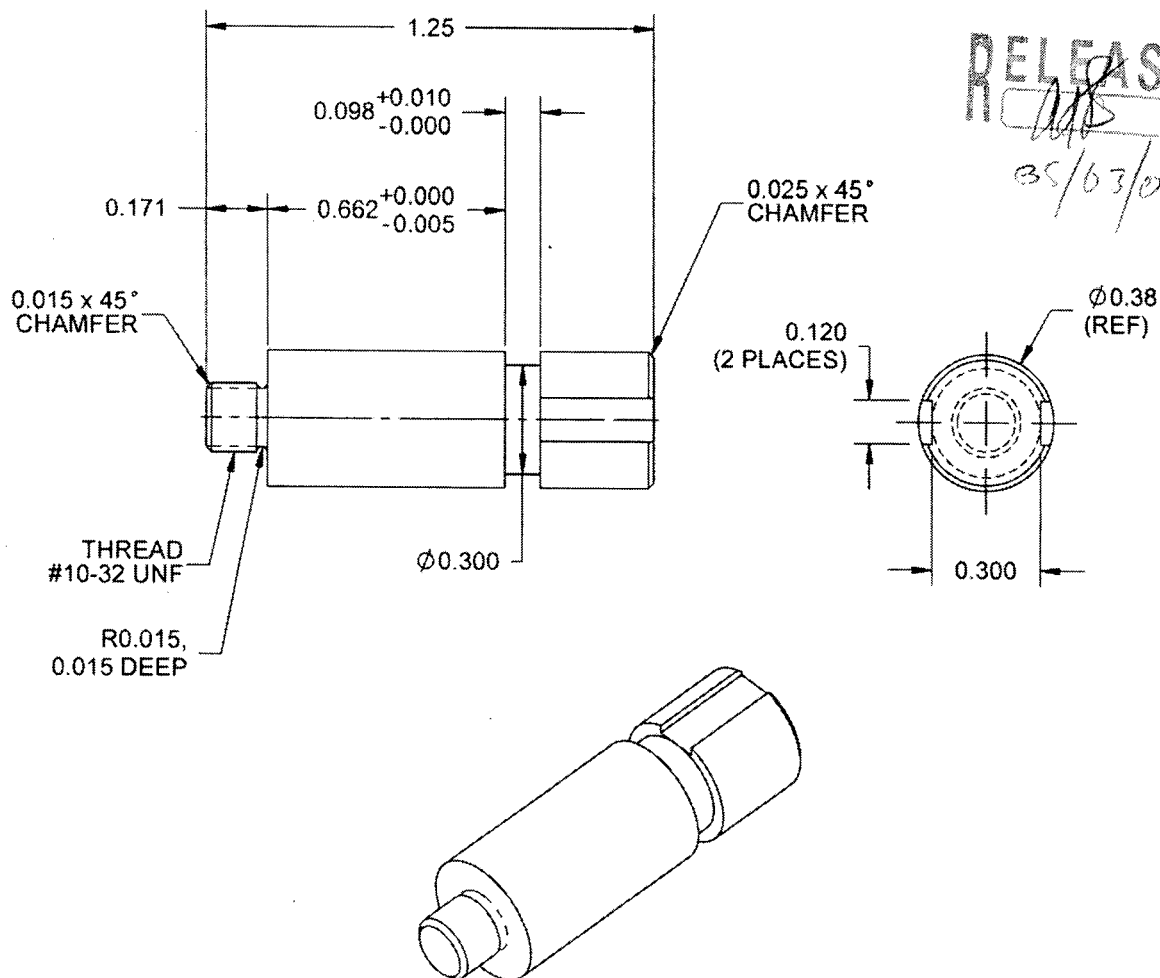
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



### D3393-3 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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